

# Work Order ID 53148

October 23, 2009 9:55:19 AM



Page 1

Item ID: D3272-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RP*

Date: *09-10-23*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

\*\*\*SQUARE ONE END BEFORE CUTTING OTHER END\*\*\* *lh*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A *lh*

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. *lh*

3-Deburr *lh*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*27 807/10/28*



# Work Order ID 53148

October 23, 2009 9:55:19 AM



Page 2

Item ID: D3272-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

Identify as per dwg & Stock Location: *W/A*

0.00

*SAD 09-10-28*

*6*



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/10/29*  
*MF 09-10-28*

# Picklist Print

October 23, 2009 9:55:24 AM

Page 1

Work Order ID: 53148

Parent Item: D3272-1RevB

Parent Item Name: Step


Comments:

Start Date: 23/10/2009

Required Date: 18/11/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120CRevC1		Manufactured	No			100	Each	177.9200	5.0000			
												
Step Extrusion												

*Handwritten:* 09.10.27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	177.92	
<del>48612</del>	68.92	
52026	109	

5



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

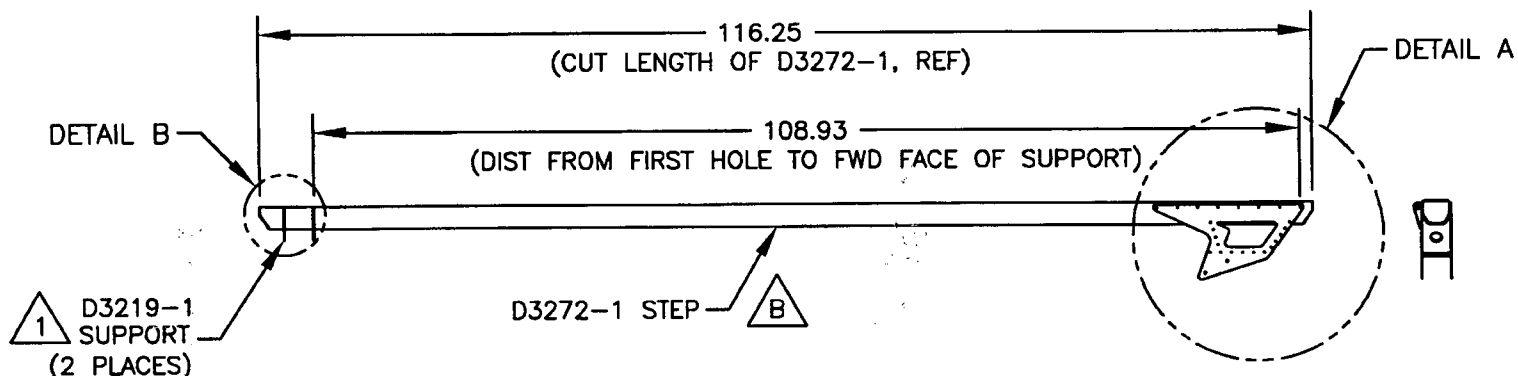
SHOP COPY  
RETURNED  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53148  
*BL 09-10-23*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

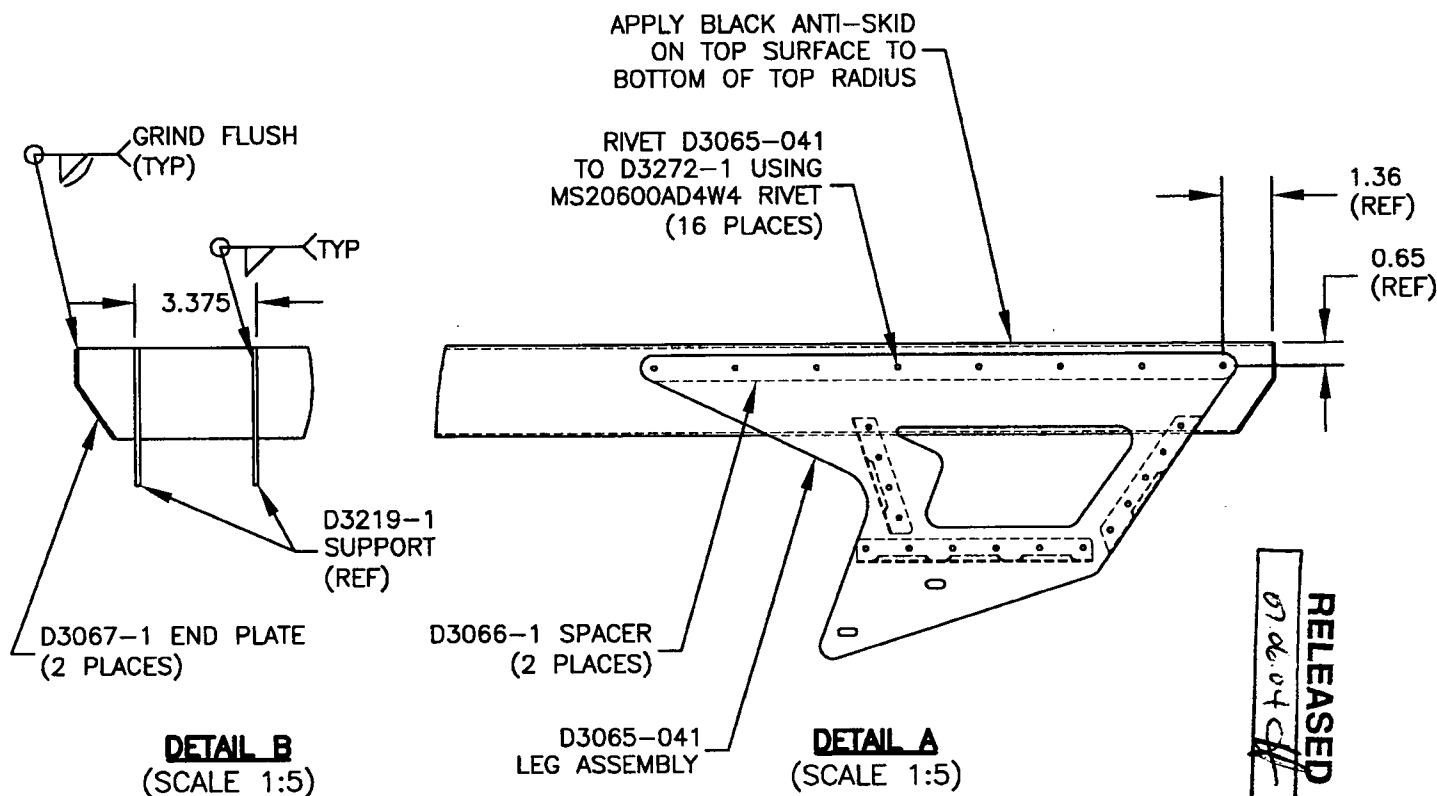
**DART**

DESIGN	40	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



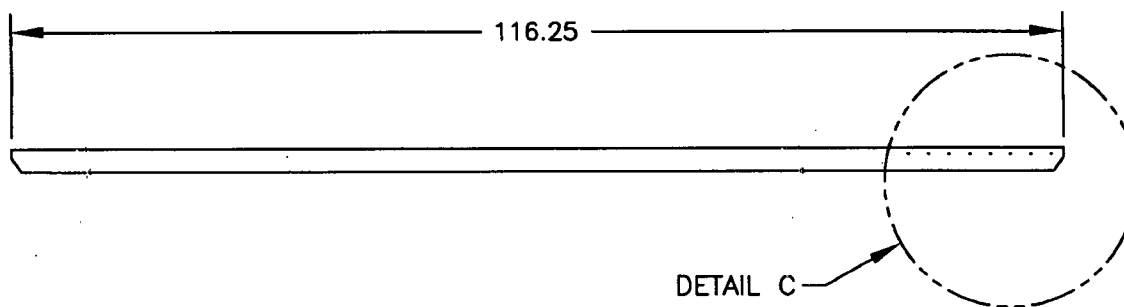
**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**

*w/d 53148*



**DART**

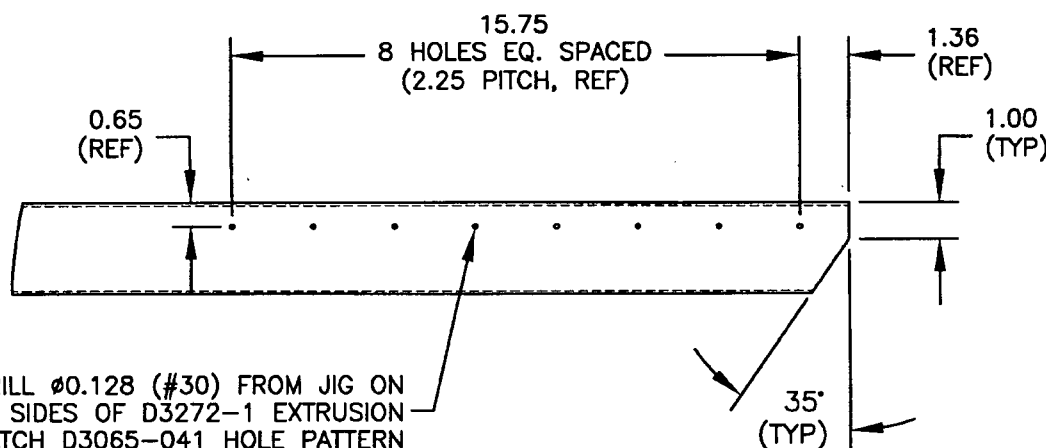
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 3
07.05.18		D3272	SCALE
		STEP ASSEMBLY, HI LONG	1:20



114.39

**D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

W/O 53148



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED  
07.06.04